

Work Order ID 128625

128625

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January-20-15 7:58:49 AM

Item ID: D3041-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 1/20/15 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-20 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3041	Rev C								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut D2423 Extrusion: 1.250" Long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Check for cracks while loading into the machine								
	Machine as per Folio FA933								
	DWG REV: _____								
	FOLIO REV: _____								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

CL 15/01/29 50

Jim Outsource 27263 Machine + powdercoat per Q5E005

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 38 9-89
130	<i>QC6</i>	0.00				<i>(50)</i>			
QC	Memo								
Quality Control									MAR 16 2015
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140	<i>HandFinish</i>	0.00							<i>CZ 15/01/29</i>
HandFinish	Memo								
Hand Finishing									
150	White Gloss (Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150	<i>White Gloss</i>	0.00							<i>CZ 15/01/29</i>
Powdercoat	Memo								
Powder Coating	START TIME: _____ OVEN TEMPERATURE: _____								
	FINISH TIME: _____								

*N/A done @
motos*

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									MAR 16 2015
170	Identify as per dwg & Stock Location: <u>2500</u>	0.00							DAS 06 9-89
170									
Packaging	Memo	0.00							
Packaging									MAR 16 2015
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									MCS 15-03-17

15-3-17

Picklist Print

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Parent Item: D3041-5

D3041-5

Parent Item Name: Clamp

Start Date: 1/20/15

Required Date: 2/06/15

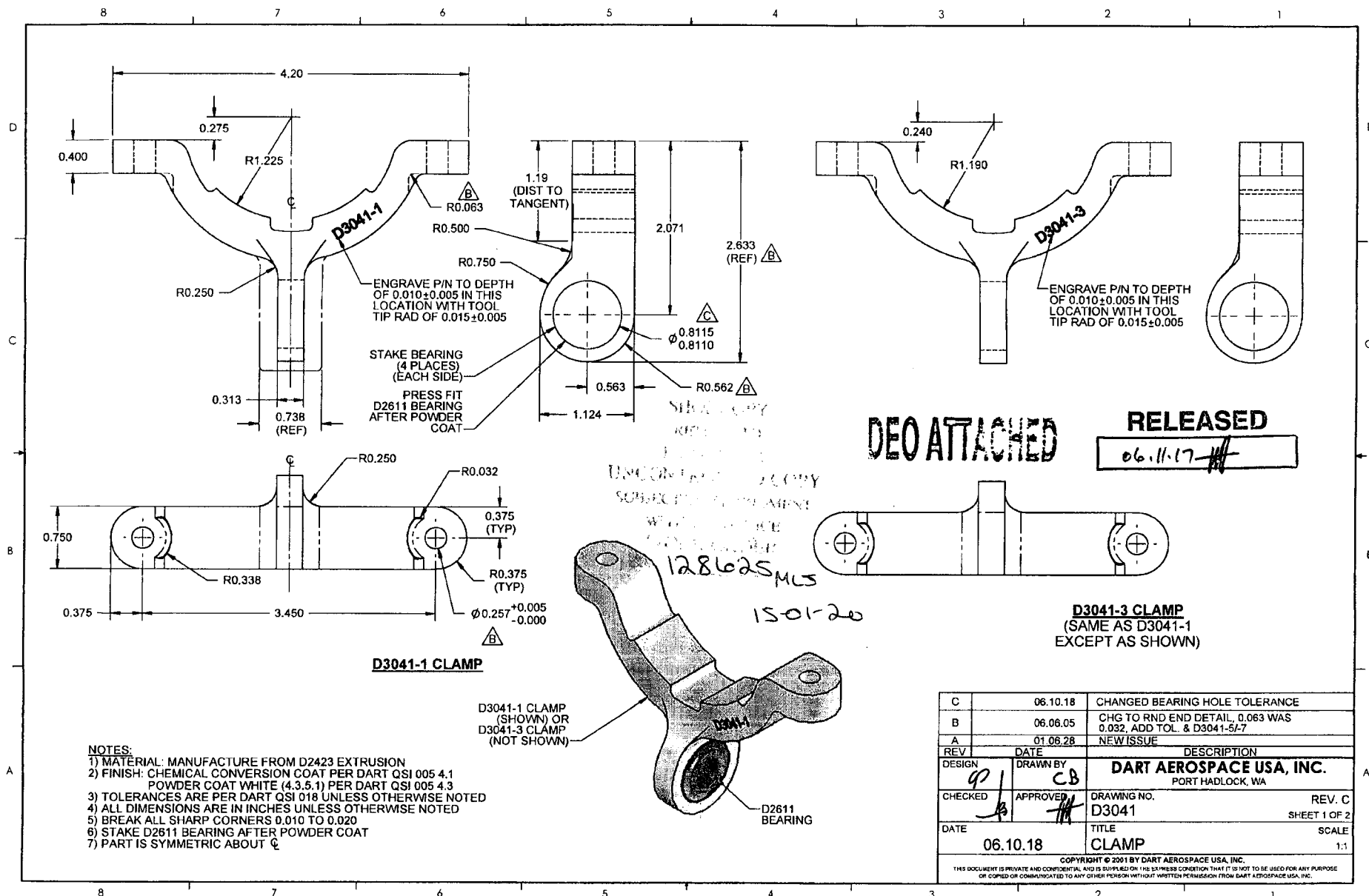
Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: A01.07.11New IssueSM/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	0.0000	0.1042	46			
D2423					B127892				**			CL 15 10/1/29	
Lug Extrusion													
D3041-5P		Purchased	No				Each	0.0000		30			
D3041-5P									**	50			
Clamp													

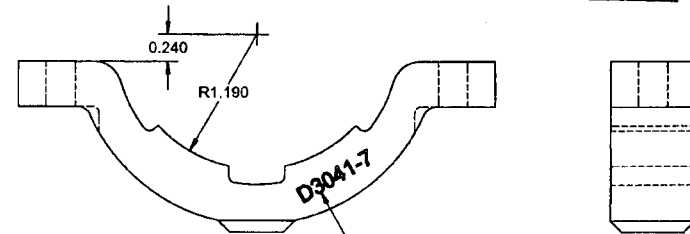
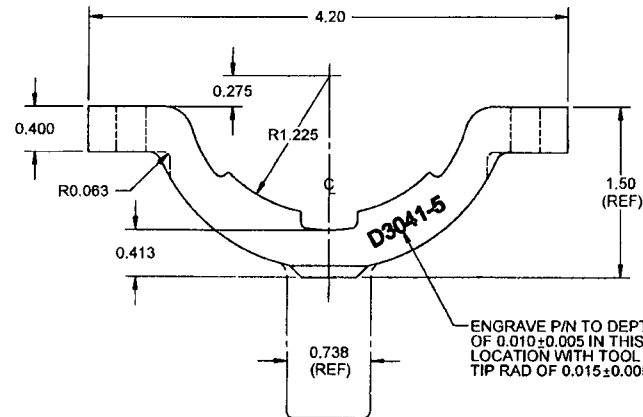
DAG
MAR 02 2015



DEO ATTACHE

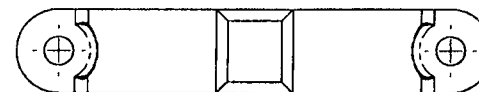
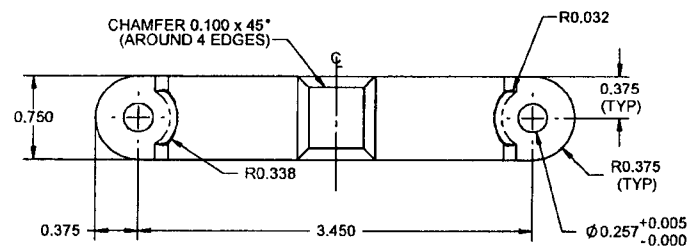
RELEASED

06.11.17



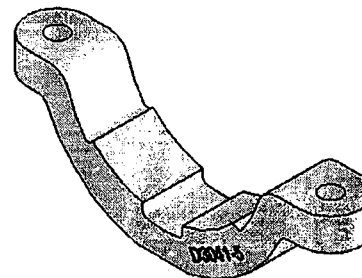
ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005

ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005



D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

D3041-5 CLAMP



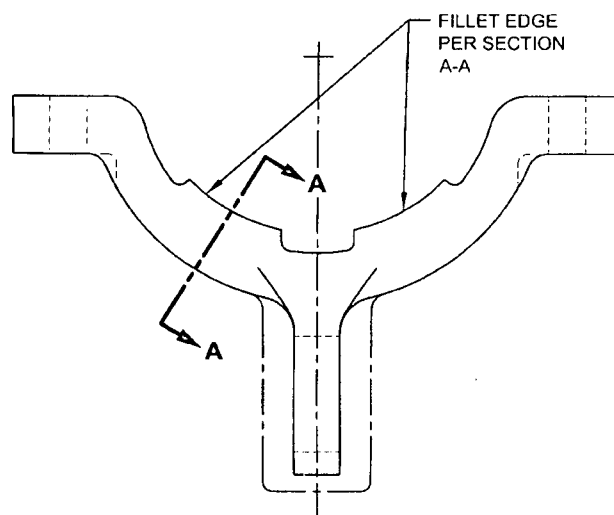
NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT C

DESIGN 97	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED B	APPROVED H	DRAWING NO. D3041	REV. C SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP		SCALE 1:1
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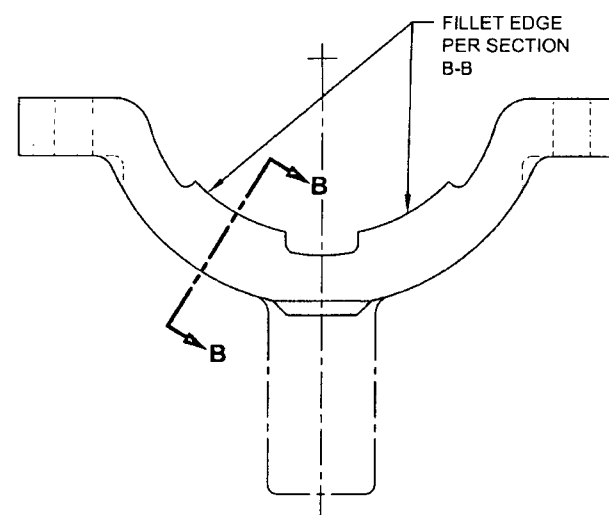
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13		DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



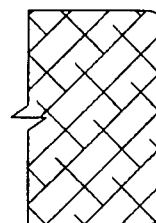
D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 19842
Date: Feb 27, 2015
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 27263	Sold By: Dewar, Eric
Shipped By: our truck	Ship Date: Feb 27, 2015

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-1 Clamp, as per drawing D3041 REV.C Alodine and paint as per QS1005 Date available February 24 2015	Each	50		50
D3041-3 Clamp, as per drawing D3041 REV.C Alodine and paint as QS1005 Date available February 24 2015	Each	30	30	
D3041-5 Clamp, as per drawing D3041 REV.C Alondine and paint as per QS1005 Date available March 3 2015	Each	50	50	
D3041-7 Clamp, as per drawing D3041 REV.C Alondine and paint as per QS1005 Date available March 3 2015	Each	30	30	
D4091-1 Lug, as per drawing D4091 Rev.A Alondine and paint as per QS1005 Date available March 3 2015	Each	30	30	
D2230-3 Mounting Lug, as per drawing D2230 REV.G Alondine and paint as per QS1005 Date available February 24 2015	Each	80	80	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

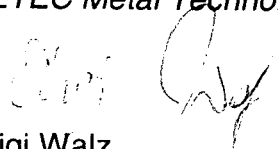
SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30	D3041-3	Clamp	27263
	MATERIAL: supplied by DART B127892		
	PAINT BATCH # 11116		
50	D3041-5	Clamp	27263
	MATERIAL: supplied by DART B127892		
	PAINT BATCH # 11112		
30	D3041-7	Clamp	27263
	MATERIAL: supplied by DART B115529		
	PAINT BATCH # 11116		
30	D4091-1	Lug	27263
	MATERIAL: supplied by DART B115529		
	PAINT BATCH # 11116		
80	D2230-3	Lug	27263
	MATERIAL: supplied by DART B115529		
	PAINT BATCH # 11112		

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, February 27, 2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27263**

Purchase Order Date 1/29/2015

PO Print Date 3/17/2015

Page Number 2 of 3

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613 678 3957

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

3	D3041-5P	Clamp	3/4/2015	50.00		\$14.00	\$700.00
			Yes	Each			
			2/4/2015				
	AS PER DWG D3041 REV. C						
	ALODINE & PAINT AS PER QSI005						
	B128625						

Line Total: \$700.00

4	D3041-7P	Clamp	3/4/2015	30.00		\$14.00	\$420.00
			Yes	Each			
			3/4/2015				
	AS PER DWG D3041 REV. C						
	ALODINE & PAINT AS PER QSI005						
	B128627						

Line Total: \$420.00

5	D4091-1P	Lug	3/4/2015	30.00		\$14.00	\$420.00
			Yes	Each			
			3/4/2015				
	AS PER DWG D4091 REV. A						
	ALODINE & PAINT AS PER QSI005						
	B128425						

Note:

3/17/2015